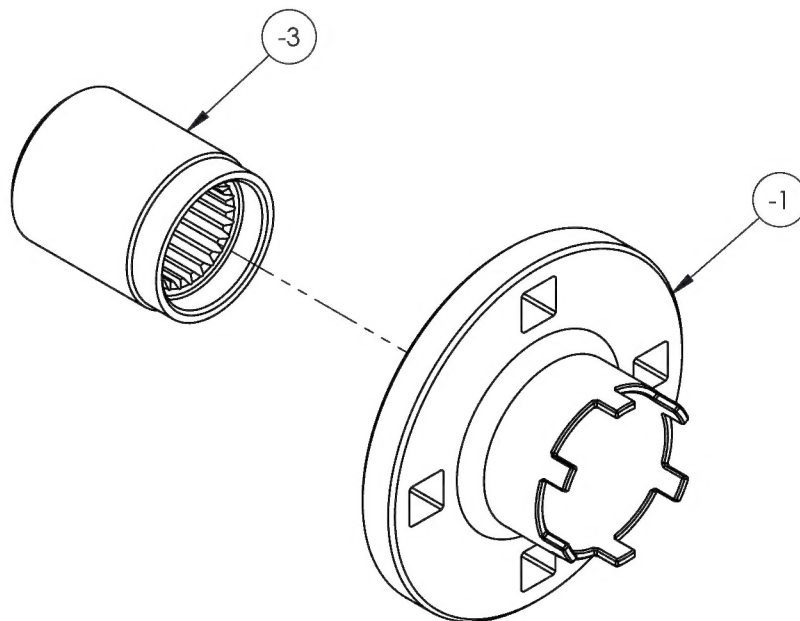


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/8/2016	RJC	JAG



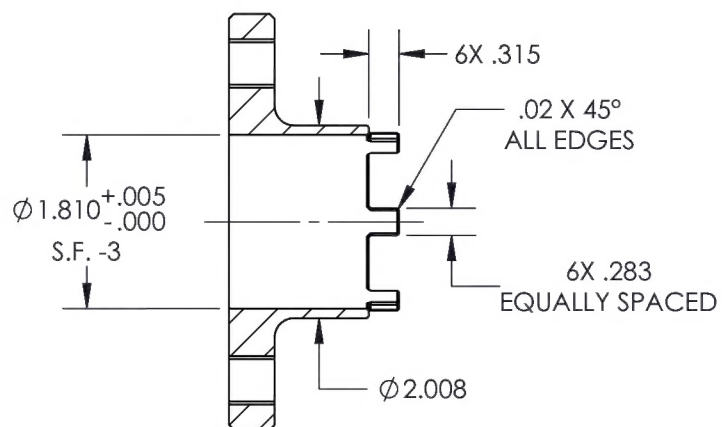
NOTE:
REF. AGUSTA T/N: 109-3130-51-101.

DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101	REV 1
MAT'L REAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	AW109
APPROVED: GILBERT	
SCALE 1:2	DATE 7/24/2013
SHEET 1 OF 3	

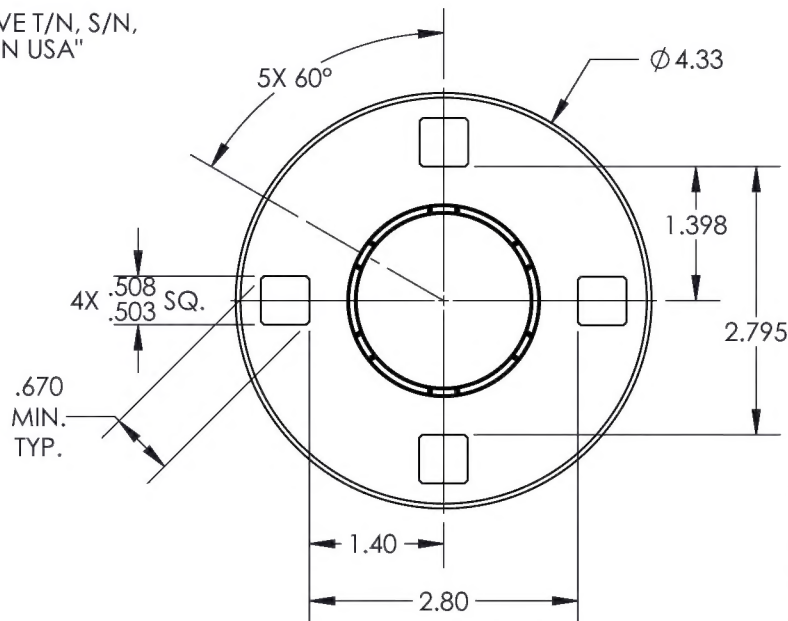
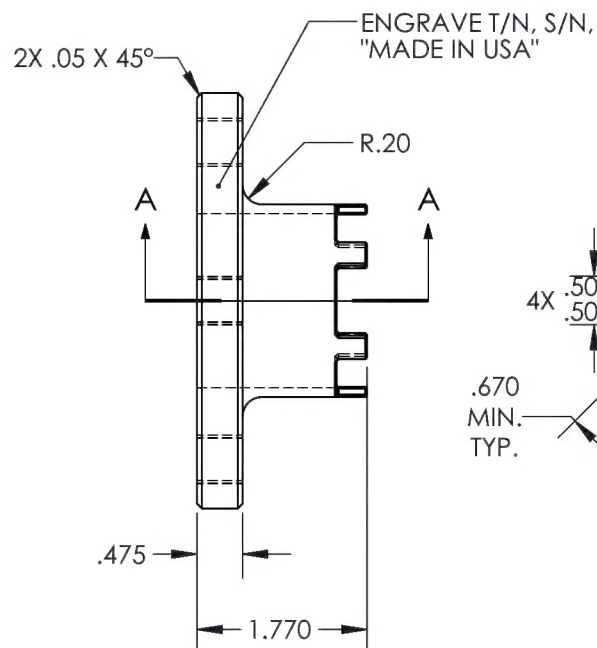
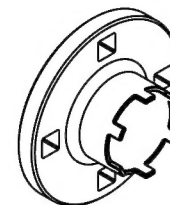
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	KEY, LOCKING	4140/4142 Q & T		2
			-3	1	WRENCH CENTERING	4140/4142 Q & T		3

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION A-A



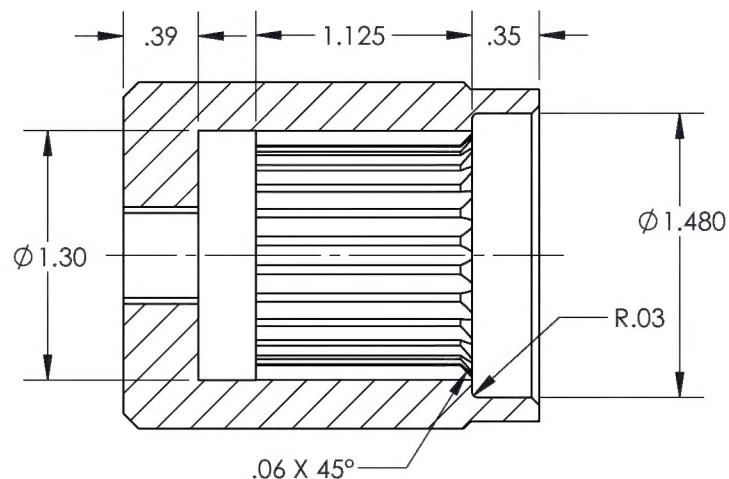
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KEY, LOCKING

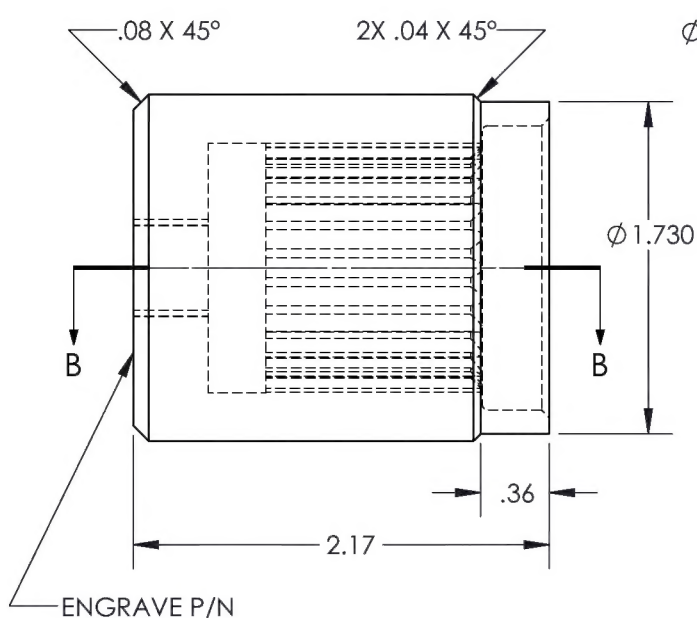
DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101-1	REV 1
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 7/24/2013	USED ON MODEL
	AW109
	SHEET 2 OF 3

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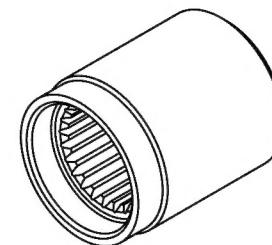
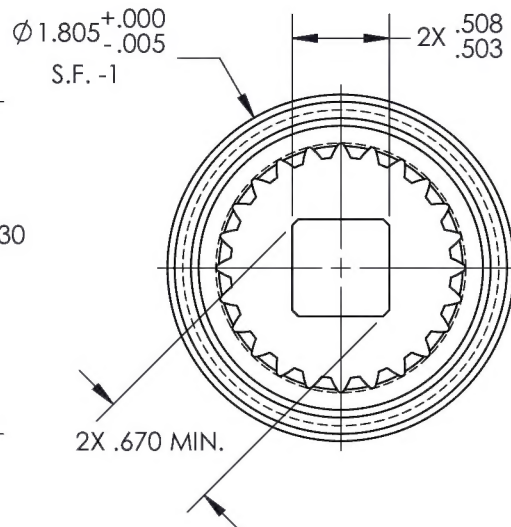
REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



SECTION B-B



WRENCH CENTERING



INTERNAL SPLINE DATA	
STANDARD	ANSI B92.1-1996
ROOT & FIT	FILLET ROOT SIDE FIT
NUMBER OF TEETH	24
DIAMETRAL PITCH	20/40
PRESSURE ANGLE	30°
MAJOR DIAMETER	1.2900 - 1.3049
MINOR DIAMETER	1.1500 - 1.2540
DIA. OVER ϕ .0864 PINS	ϕ 1.0778 - 1.0803
TOLERANCE CLASS	CLASS 5 FIT

DART AEROSPACE	
TITLE TAIL ROTOR BRAKE NUT REMOVAL / INSTALLATION TOOL	
DWG NO. RBW109-3130-51-101-3	REV 1
MATERIAL 4140/4142 Q & T	
HEAT TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY: CLOUGH	
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	
DATE 7/24/2013	
SHEET 3 OF 3	

- UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS \pm 1/8
ANGLES \pm 5°
SURFACES = 125°
- BREAK ALL SHARP EDGES
.015 x 45° OR .015R
 - DIMENSIONAL LIMITS APPLY
AFTER PLATING
 - INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL

AW109